

# Work Order ID 119780

\*119780\*

Page 1

May-22-14 1:23:01 PM

Item ID: D3063-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Support

Start Date: 22/05/2014 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 24/05/2014 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

Date: 14.05.22

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3063	Rev A

100		0.00							
*100*	SHEAR								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 4.000" x 2.500" x 0.625" thick								

DAS  
37  
9-89 14.05.22

110		0.00							
*110*	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA175 and Dwg D3063 2-Deburr & Tumble								

DAS  
37  
9-89 14.05.22

120		0.00							
*120*	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

DAS  
37  
9-89 14.05.22

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

DAS

14

9-89

14/05/26

140

Identify as per dwg & Stock Location: WAS

0.00

\*140\*

Packaging

Memo

0.00

Packaging

\*\*\* STOCK IN STEP CELL\*\*\*

20

CP

14.7.9

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.00

Quality Control

MLJ 14-07-09

14.7.9

# Picklist Print

May-22-14 1:23:00 PM

Page 1

Work Order ID: 119780

**\*119780\***

Parent Item: D3063-1

**\*D3063-1\***

Parent Item Name: Support

Start Date: 22/05/2014

Required Date: 24/05/2014

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C02.10.04Re-format; Blank size changeKJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.625X02.50  
0

Purchased

No

100

f

12.0000

0.3417

8

**\*M6061T6B0 625X02 500\***

6061-T6 Bar .625 x 2.50

\*\*

DAS

37

9-89 14.05.22

Location

Loc Qty

Loc Code

MAT002

12

M128865

12

7ft

119780  
H3631

DART AEROSPACE LTD		Work Order:	H3631
Description: Support		Part Number:	D3063-1
Inspection Dwg: D3063	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	R.063	✓		RAD GAUGE	
R0.125	+/-0.010	R.125	✓			
0.566	+/-0.010	.566	✓		"	"
0.375	+/-0.010	.375	✓		"	"
Ø0.257	+0.005/-0.000	Ø.259	✓		Pin GAUGE	
R0.375	+/-0.010	R.375	✓		RAD GAUGE	
0.125	+/-0.010	.125	✓		"	"
2.293	+/-0.005	2.293	✓		"	"
0.490	+/-0.010	.488	✓		"	"
0.188	+/-0.010	.186	✓		DR.6	B'over
2.960	+/-0.010	2.963	✓		DR.6	B'over.

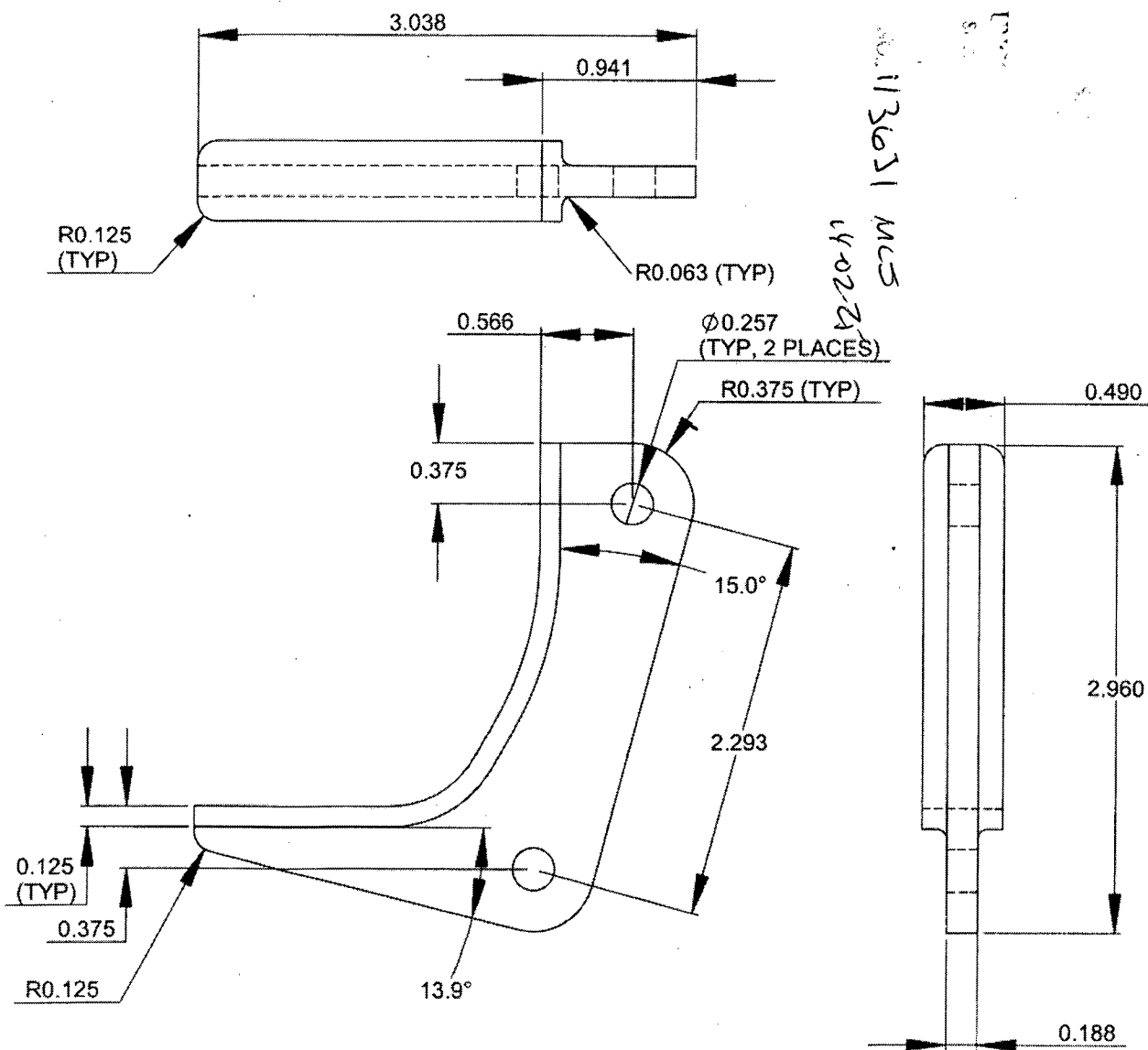
Measured by: <b>DAS 37</b> Date: 14.05.22		Audited by: <b>DAS 14</b> Date: 14/05/26		Prototype Approval: N/A Date: N/A	
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Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3063</b>	REV. A SHEET 1 OF 1
DATE <b>02.09.10</b>		TITLE <b>SUPPORT</b>	SCALE 1:1
A	02.09.10	NEW ISSUE	

RELEASED  
02.09.20



1) MACHINE PER DWG FILE "D3063-1.SLDPRT"  
2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)  
(REF DART SPEC M6061T6B OR M6061T6S)  
3) FINISH: NONE  
4) BREAK ALL SHARP EDGES 0.005 TO 0.015  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

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